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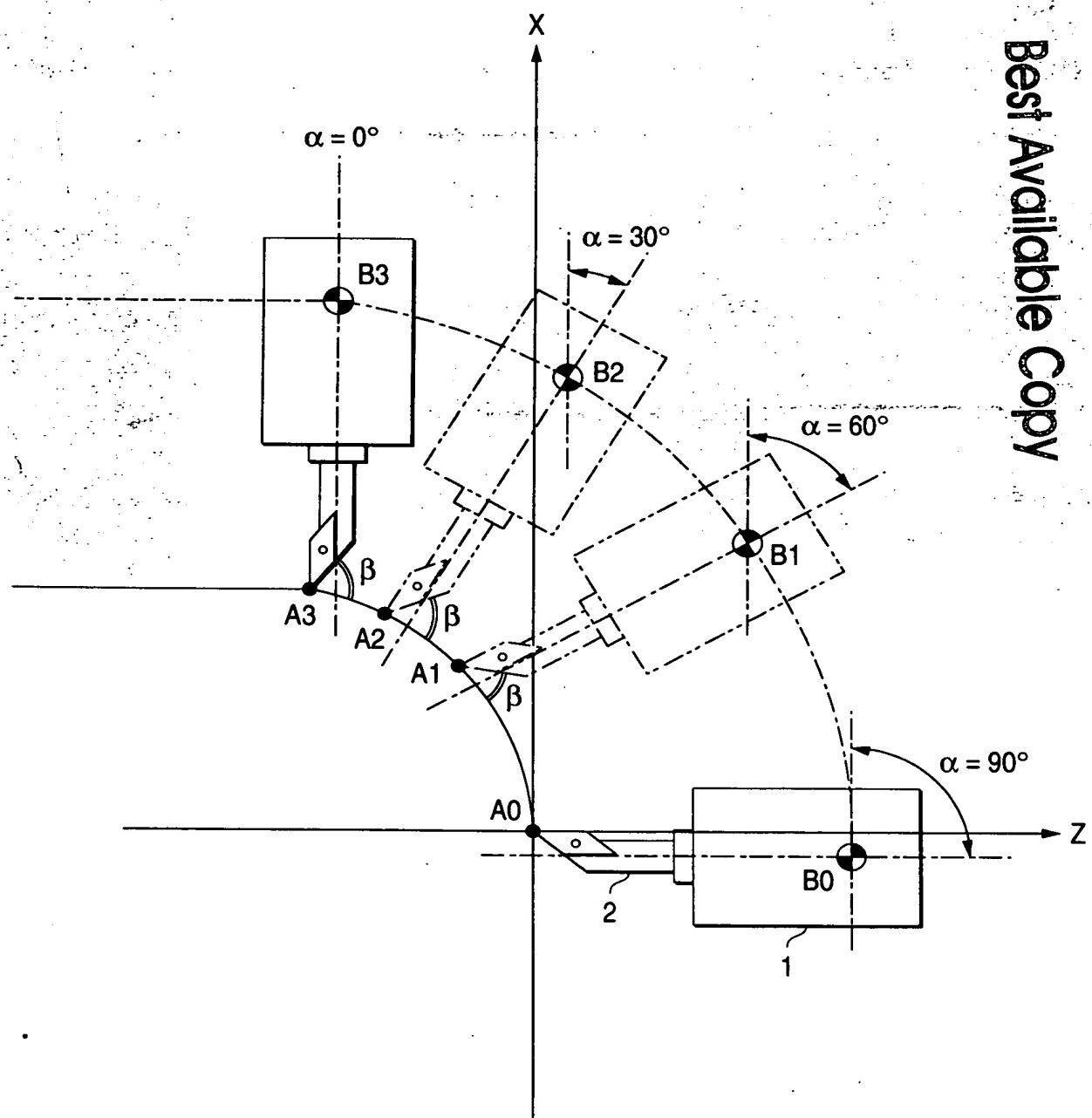
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FIG. 1

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FIG. 2

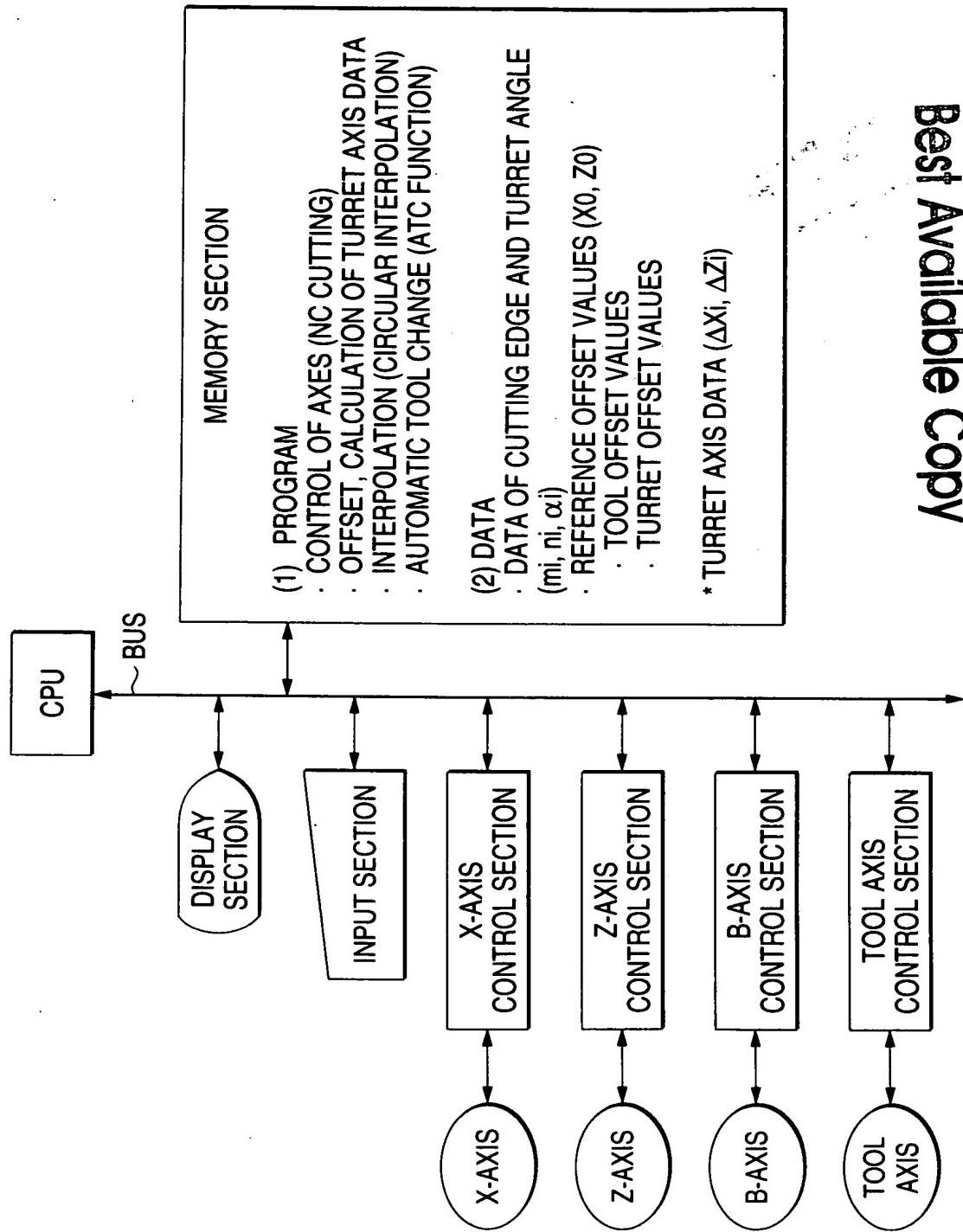


FIG. 3A

CUTTING EDGE POSITION	X CUTTING EDGE DATA mi	Z CUTTING EDGE DATA ni	TURRET ANGLE α_i
A0	0	0	90°
⋮	⋮	⋮	⋮
A1	20	-10	60°
⋮	⋮	⋮	⋮
A2	30	-20	30°
⋮	⋮	⋮	⋮
A3	35	-30	0°

FIG. 3B

TURRET AXIS POSITION	ΔX_i	ΔZ_i	TURRET ANGLE α_i
B0	-5	40	90°
⋮	⋮	⋮	⋮
B1	35.7	27.1	60°
⋮	⋮	⋮	⋮
B2	62.1	4.3	30°
⋮	⋮	⋮	⋮
B3	75	-25	0°

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FIG. 4

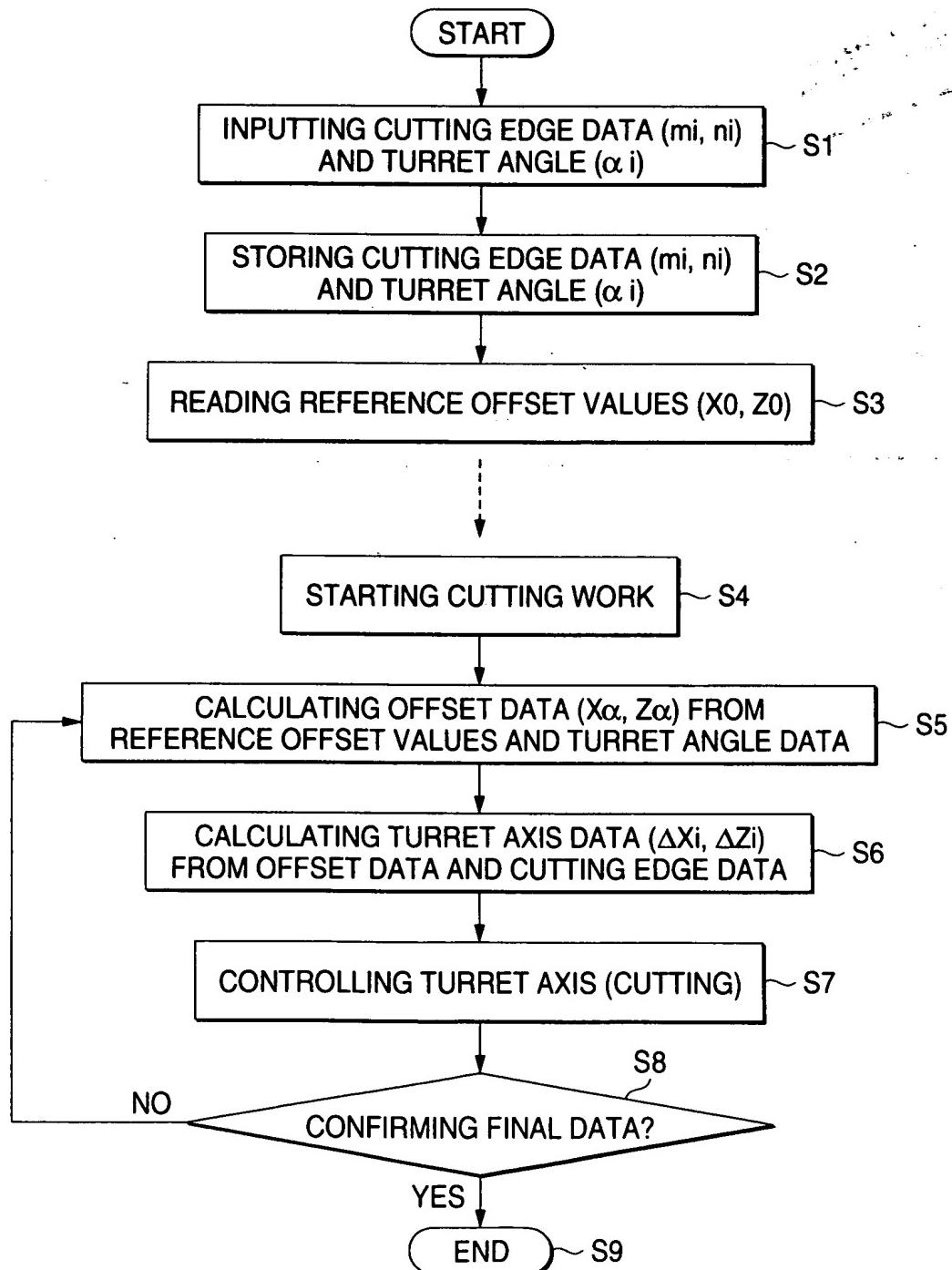


FIG. 5

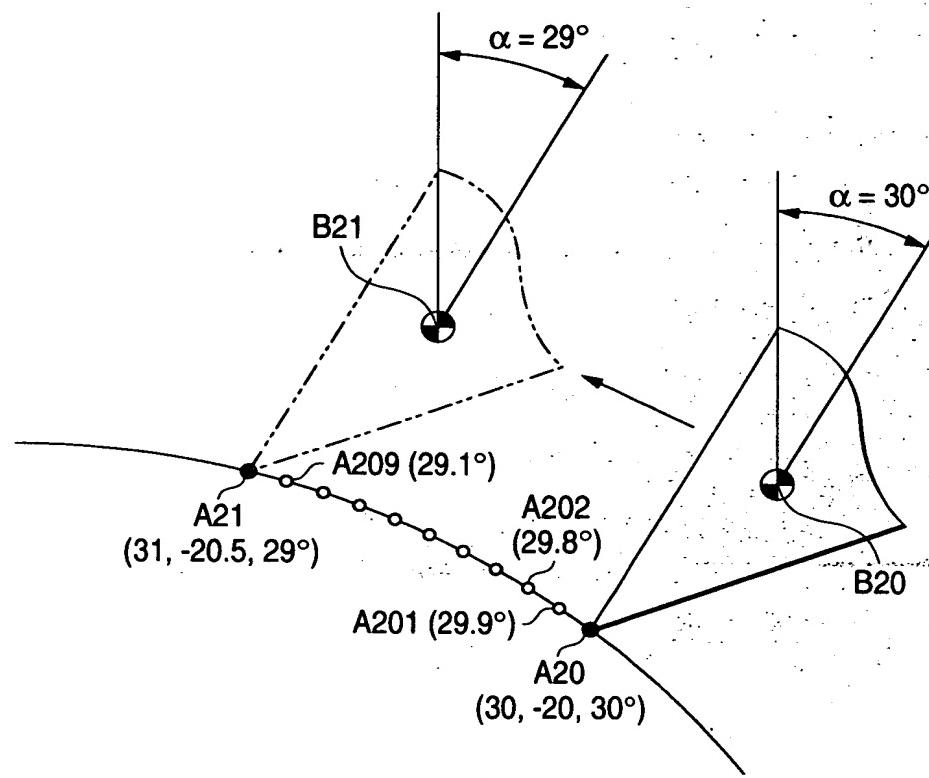


FIG. 6

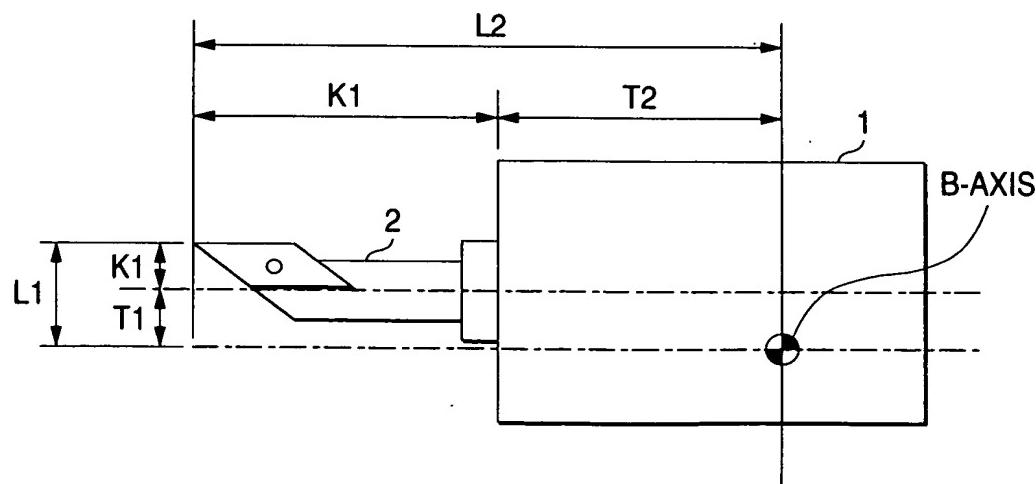


FIG. 7

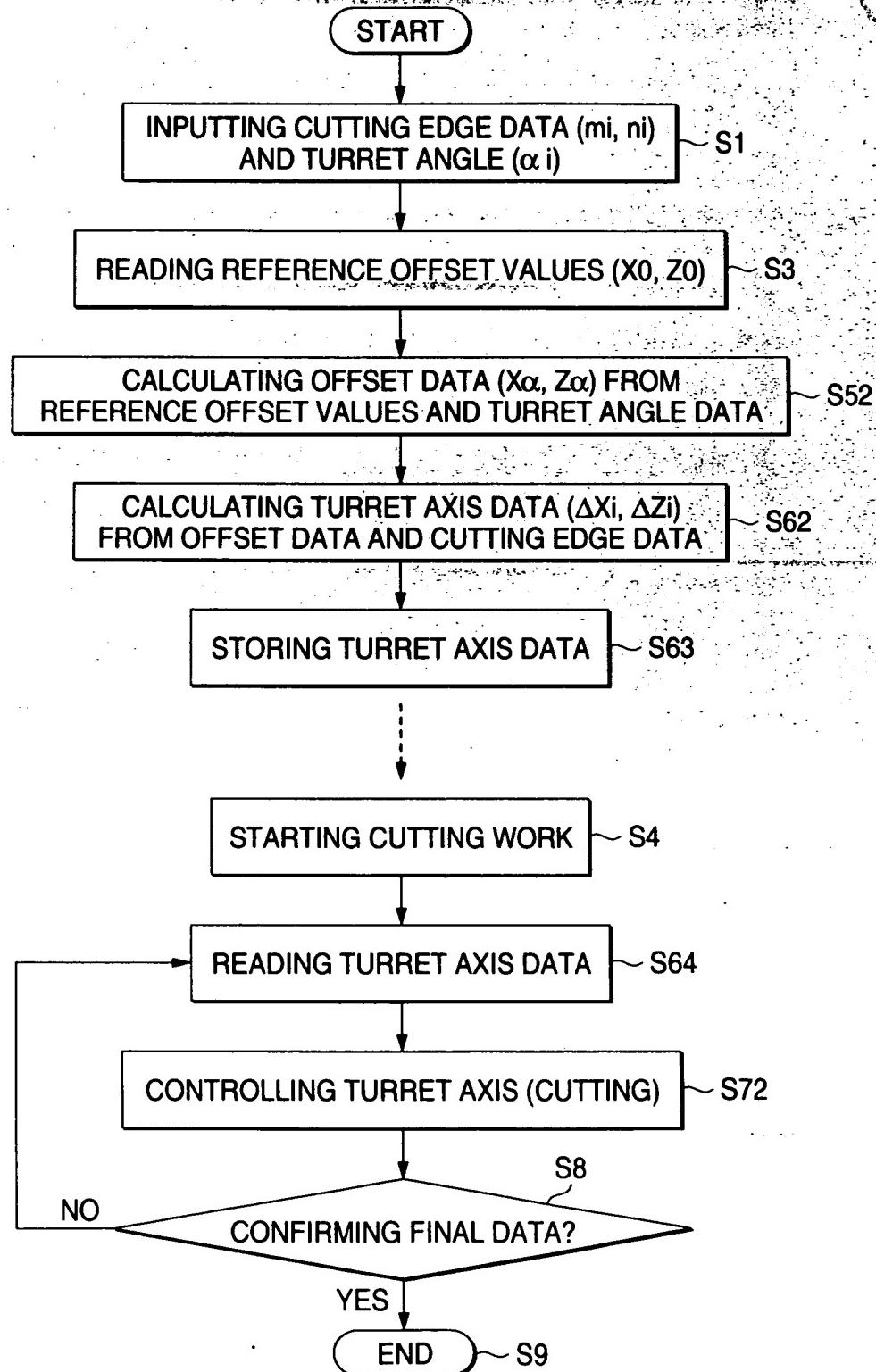


FIG. 8

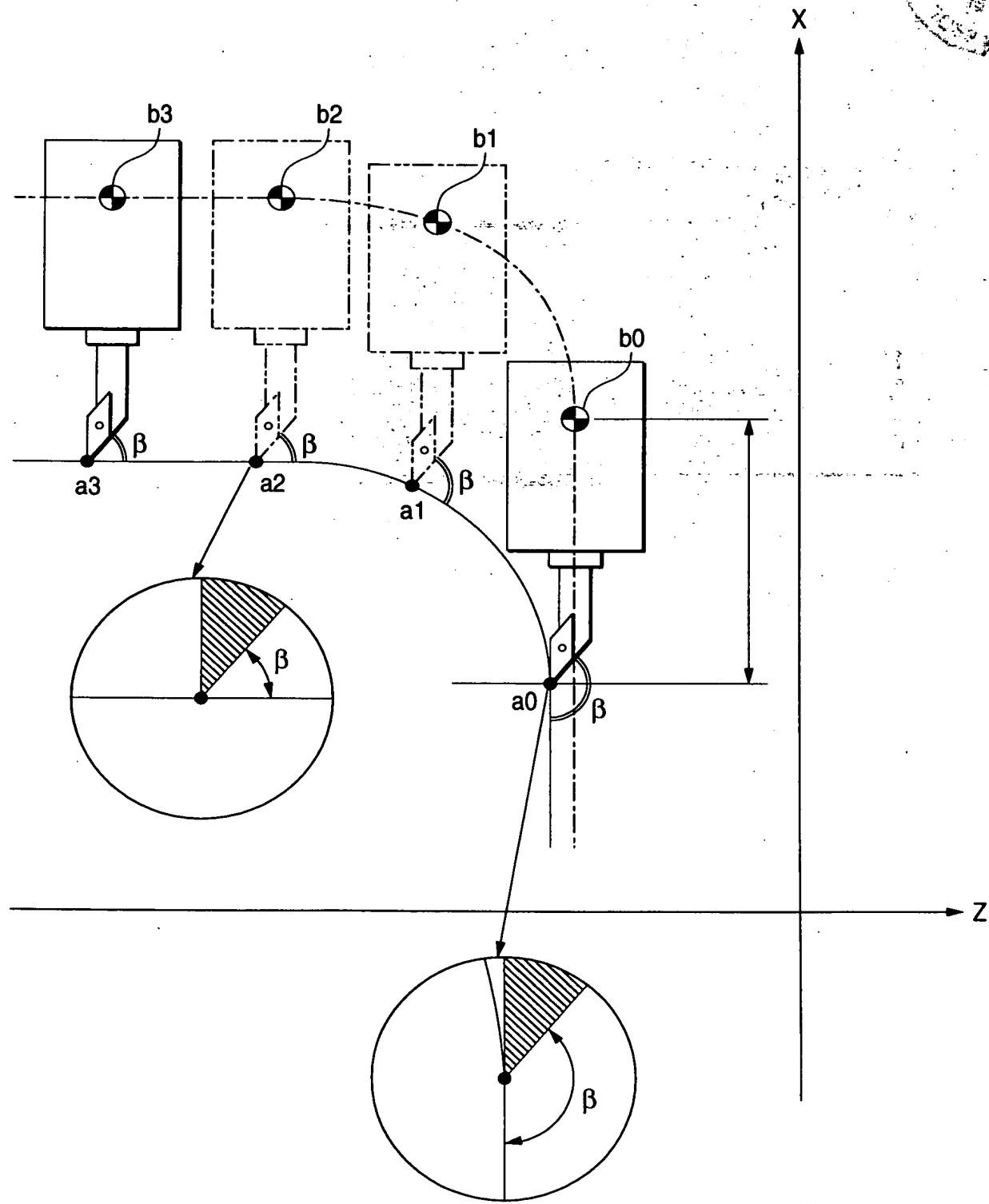


FIG. 9

